

Date: Monday, 3/17/2008 11:56:45 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	1/4 TURN FASTNER RAIL (BLACK)		
Job Number	38022	Part Number	D103858B		
Estimate Number	10096	Drawing Number	D1038		
P.O. Number		Project Number	N/A		
This Issue	3/17/2008	Type	MACHINED PARTS		
Prsht Rev.	NC	Drawing Revision	B		
First Issue	/ /	Material			
Previous Run	34968	Due Date	3/31/2008	Qty:	100
Written By		Um:	Each		
Checked & Approved By	<i>JK 0803 17</i>				
Comment	Est: E 03.05.02 Reformat; Added label KJ/RF Est Rev:F 06-08-16 Updated Packaging Procedures JLM				

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description:	
1.0	DC	DOCUMENT CONTROL	
2.0	D2023	Extrusion, Fastener Rail	
3.0	BAND SAW	BAND SAW	
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
6.0	QC8	SECOND CHECK	

Comment: DOCUMENT CONTROL
Create white labels and bag them 08.04.08 JD

Comment: Qty.: 1.9030 f(s)/Unit Total : 190.3000 f(s)
Extrusion, Fastener Rail M21907

Comment: BAND SAW
Cut extrusion D2023 to length 21.81" (+0.06/-0.00) Batch #: *1821907* H.A 08/03/20

Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine as per Folio and Dwg D1038-58 JL/H.A/ 08/03/20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE JL/H.A/ 08/03/20

Comment: SECOND CHECK SD 08/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 1/4 TURN FASTNER RAIL (BLACK)

Job Number: 38022

Part Number: D103858B

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

3/08/03/25 *(100)*

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

3/08/03/25

6/08/03/25 *(X100)*

9.0 OUTSIDE SERV.30.

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 5988

Black Anodize as per Dwg D1038

3/08/03/25 *(100)*

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

3/08/03/25 *(100)*

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

3/08/03/25 *(X100)*

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389

Batch: M 18727
M 104298

2-Grind wire flush and deburr

X100

3-Clean

3/08/04/07

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

3/08/04/07 *(X100)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Roll Part in foam .

3-Install red cap at each end and secure with tape.

4-Apply white labels to cardboard tubes

5-Identify and Stock

Location: Packaging

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF

08-04-08.

CJLH

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38022
Description: 1/4" Turn Fastener	Part Number:	D1038-58B
Inspection Dwg: D1038-58B Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: H.A /
 Date: 08/03/20

Audited by: DJP
Date: 08/03/20

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.16	New Issue	KJ/JLM	
B	06.03.08	21.750 was 12.750, Dwg rev. changed	KJ/JLM	

DART**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

REV. B

DESIGN 44 DRAWN BY JLCHECKED JL APPROVED JL

DRAWING NO. D1038

SHEET 1 OF 1

DATE 05.02.02

91.05.05 NEW ISSUE

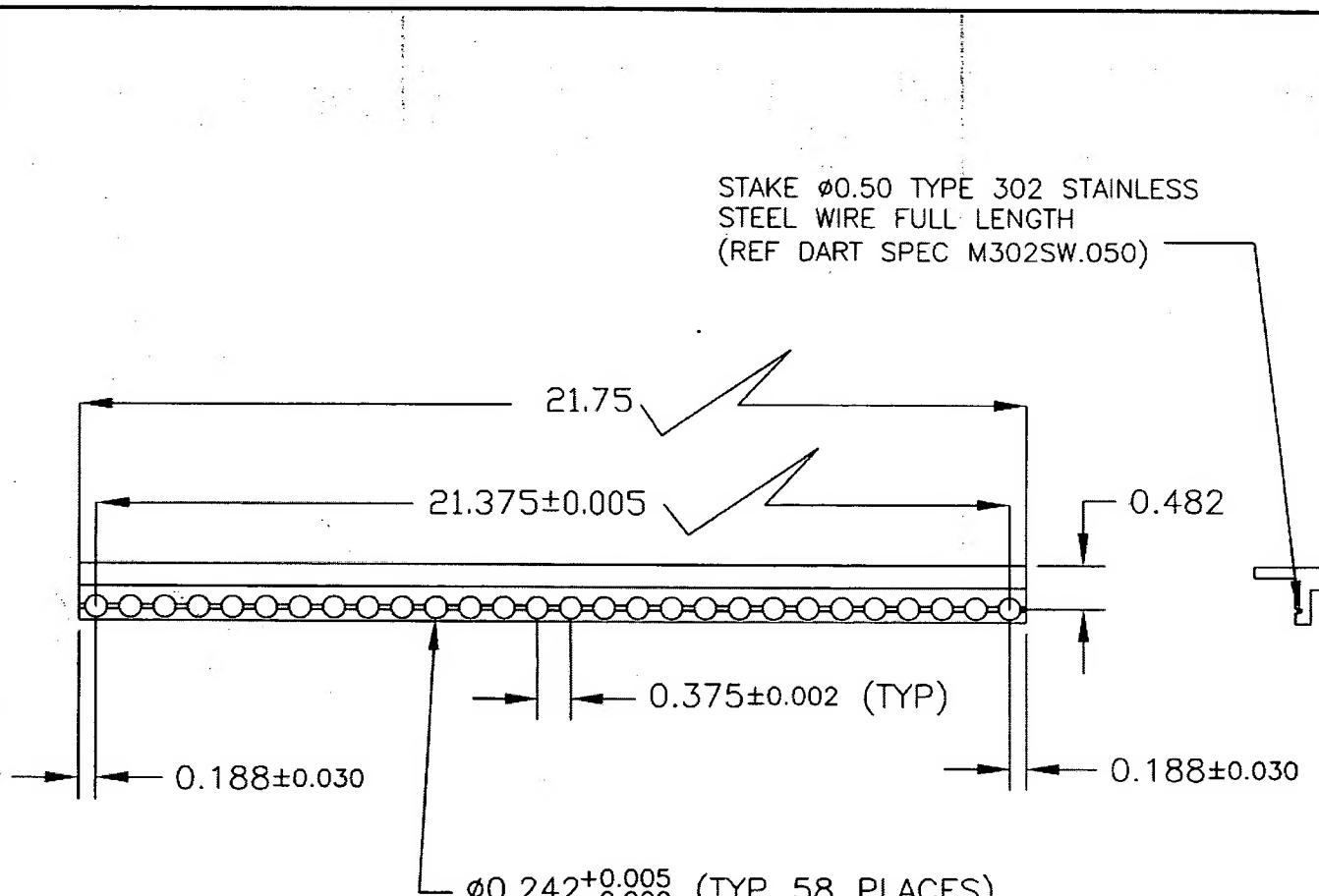
SCALE 1/4

TITLE 1/4 TURN FASTENER RAIL

REVISIONS

A 04.05.14 UPDATE TOLERANCE

B 05.02.02 REDRAWN, UPDATE NOTES

RELEASED
05.03.31 JLSTAKE $\varnothing 0.50$ TYPE 302 STAINLESS
STEEL WIRE FULL LENGTH
(REF DART SPEC M302SW.050)D1038-58 1/4 TURN FASTENER RAIL

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10

DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1) SHOP COPY
2) RETURN TO
3) ENGINEERING
4) AMENDMENT
5) NOTICE
6) WITHOUT NOTICE
7) WORK ORDER
8) NO. 38022

TNM**ANODISATION et PEINTURE TNM INC.****C. OF C**

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

63408

31-Mar-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE**CERTIFICAT DE CONFORMITE****NO. DE COMMANDE: 214586****PURCHASE ORDER/**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	5	5	D2224 B 37744	RED ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
2	31	31	D2091 B 30137	BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
3	100	100	D1038-58B B 38022	BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:**Directeur de la Qualité / Q.A. Manager**